



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3011-1

Job Sheet 203561



Part No: D3011-1

Job Qty: 6 pcs

Part Name: Rappel Slide Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/19

Job Tracking No:

Due Date: 12/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3011 REV D IPP C 02.05.09 Added D6202 at step 2 NG IPP Rev:D Added QC8 JLM Verified By:EC
IPP REV:E 13.06.26 AS PER DWG REV.C DD VERF:JFS IPP REV:F 18.10.26 AS PER DWG REV.D DD
VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		12/10/19	0.00	0.02	Bandsaw - 1		JSD 20-2/24
110	HAAS 4 Axis - B4B	6 pcs		12/10/19	1.00	4.10	HAAS - 1 - B4B		JSD 20-2/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		12/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S259565



Part: D3011-1

Job No: 203561

Serial No/Batch: S259565

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/29/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	MM 20-2-24
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	6 pcs	12/10/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
131 Outsource - 2 - NDT per QSI038	6 pcs	12/10/19		SKY002-VC	5 2020-03-05
132 Packaging 2-1 - Receive - B4B	6 pcs	12/10/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	MAR 0 5 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	

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				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
135 QC 6	6 pcs	12/10/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	MAR 05 2020
				QC 6 - 81	DAS 40 9-89
140 Handfinish - 1-1 Chemical-B4B	6 pcs	12/10/19	0.00 0.86	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	MAR 09 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

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				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	6 pcs	12/10/19	0.00 1.07	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	6 pcs	12/10/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
170	Packaging 3-1 - Stock - B4B	6 pcs	12/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

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				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				180 QC 21 - SA	6 pcs
				QC 21 - SA - 70	
				QC 21 - SA - 53	

MAR 19 2020

Part Op 100 - (Bandsaw)Cut Blanks: 26.625"
 Descriptions: 110 - (HAAS CNC Vertical Machine)Machine as per folio FA129 Folio Rev: AA Dwg
 Rev: D ***ENSURE SURFACES ARE SMOOTH, BUFF ALL SCRATCHES AS REQUIRED AS PER
 NOTE 11 DWG D3011***
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - QC8- Inspect parts - second check)
 131 - (Outsource process - NDT per QSI038 4.1)1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG D3011 2- Certificate
 of conformity is required
 132 - (Receive & Inspect for Damage & Mat'l Certs)
 135 - QC6- All purchased or subcontracted products)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____ OVEN TEMP: _____ FINISH
 TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6202	I-Beam Extrusion	12.9996 ft (2.1666 ea)	100-Bandsaw - 1	5132212

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6202	13	25	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rappel Slide Bar	26.410Inches ± 0.030	26.440 26.380		
2	Rappel Slide Bar	2.310Inches ± 0.030	2.340 2.280		
3	Rappel Slide Bar	2.360Inches ± 0.030	2.390 2.330		
4	Rappel Slide Bar	1.120Inches + 0.030 - 0.010	1.150 1.110		
5	Rappel Slide Bar	1.685Inches + 0.030 - 0.010	1.715 1.675		
6	Rappel Slide Bar	1.745Inches + 0.030 - 0.010	1.775 1.735		
7	Rappel Slide Bar	1.250Inches + 0.030 - 0.010	1.280 1.240		
8	Rappel Slide Bar	2.500Inches + 0.030 - 0.010	2.530 2.490		
9	Rappel Slide Bar	2.125Inches + 0.030 - 0.010	2.155 2.115		
10	Rappel Slide Bar	0.275Inches + 0.030 - 0.010	0.305 0.265		
11	Rappel Slide Bar	0.375Inches ± 0.030	0.405 0.345		
12	Rappel Slide Bar	0.386Inches + 0.006 - 0.006	0.392 0.385	Diameter	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 203561
Description: Rappel Slide Bar		Part Number: D3011-1
Inspection Dwg: D3011-1 Rev: 0 D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.41	+/-0.030	26.4046	✓		Haas 1	
2.31	+/-0.030	2.30	✓		Vernier	CNC-019
2.36	+/-0.030	2.360	✓		"	"
1.120	+0.030/-0.010	1.120	✓		Vernier	CNC-019
1.685	+0.030/-0.010	1.6904	✓		Haas 1	
1.745	+0.030/-0.010	1.750	✓		Vernier	CNC-019
1.250	+0.030/-0.010	1.260	✓		"	
2.500	+0.030/-0.010	2.500	✓		"	
2.125	+0.030/-0.010	2.120	✓		"	
0.275	+0.030/-0.010	0.292	✓		Mike	
0.375	REF	0.370	✓		Height gage	
Ø0.386	+0.006/-0.001	.386	✓		Vernier	CNC-019

Measured by: JBD	Audited by: P	Preliminary Approval:
Date: 20-2-28	Date: 20/03/04	Date:

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	09.09.14	Dimensions revised per Dwg Rev B	KJ	
C	13.07.18	Dwg Rev updated	KJ	

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO43829	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB046014
Descr: *	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES + 6 RAPPEL SLIDE BAR

ITEM ID: D350-748-203 AS350 / AS355 STAINLESS STEEL AFT CROSSTUBE

- 1 - JOB SHEET ID#: 197821
- 2 - JOB SHEET ID#: 200615
- 3 - JOB SHEET ID#: 200614
- 4 - JOB SHEET ID#: 200547

ITEM ID: D412-664-203 AFT CROSSTUBE - HIGH

- 5 - JOB SHEET ID#: 204617
- 6 - JOB SHEET ID#: 202950
- 7 - JOB SHEET ID#: 204618
- 8 - JOB SHEET ID#: 202951

ITEM ID: D3011-1 RAPPEL SLIDE BAR QTY (6)
10 - JOB SHEET ID#: 203561

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9-89**RECEIVED****MAR 05 2020****DART AEROSPACE LTD.**

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-10) AS PER ASTM1417M-16 NO CRACK FOUND LP ZL-37 BATCH#: MPO21721, CLEANER SKC-S BATCH#: MPO25754, EMU ZR-10E BATCH#: MPO26014, DEV SKD-S2 BATCH#: MPO23451, UV LIGHT M-20338	MAR 05 2020	 
Miscellaneous AD Review Performed: ☐ No applicable AD's noted ☐ Refer to action taken for applicable AD's		
Description	Location	P/N
	Qty	Batch
	S/N Off	S/N On
MIA		

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: ANTONINO MARCHETTA		MAR 05 2020



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB046014**



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046014

PO Date: 3/4/20

Due Date: 3/6/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203561	D3011-1	D3011 Rev D	Rappel Slide Bar : Various STC's (Outsource process - NDT per QSI038 4.1) 1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG D3011 2- Certificate of conformity is required	Firmed	-	3/6/20	6 pcs	0 pcs	6 pcs	\$33.3333/pcs	\$200.00
2	202951	D412-664-203	D412-664-243/IIN-D212-664 Rev F/J	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	3/6/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	204618				Firmed	-	3/6/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	202950				Firmed	-	3/7/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	204617				Firmed	-	3/8/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
								Sub Total:	4	0	4	\$527.50
3	200547	D350-748-203	D350-748-243 Rev A	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	3/6/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	200614				Firmed	-	3/6/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	200615				Firmed	-	3/7/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	197821				Firmed	-	3/8/20	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
								Sub Total:	4	0	4	\$527.50
											Grand Total:	\$1,255.00

Guérin